

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017837**Date Inspected:** 04-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segments**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Dan Hernandez was present during the times noted above to observe the fit up, welding and related activities associated with the fabrication of the San Francisco Oakland Bay Self Anchored Suspension Bridge at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

OBG Trial Assembly Yard

Segment 11DW/11EW

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated OBW11C-009, Side Plate transverse splice. The welder is identified as #049220 and was observed welding in the 3G (vertical) position using approved Welding Procedure Specification WPS-B-T-2233T.

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated OBW11C-010, Side Plate transverse splice. The welder is identified as #040759 and was observed welding in the 3G (vertical) position using approved Welding Procedure Specification WPS-B-T-2233T.

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated OBW11C-006, Side Plate transverse splice. The welder is identified as

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#040609 and was observed welding in the 3G (vertical) position using approved Welding Procedure Specification WPS-B-T-2233T.

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated OBW11C-009, Side Plate transverse splice. The welder is identified as #046706 and was observed welding in the 3G (vertical) position using approved Welding Procedure Specification WPS-B-T-2233T.

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated OBW11A-006, Edge Plate transverse splice. The welder is identified as #040611 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-B-P-2214-B-U2-FCM-1.

Segment 11CW/11DW

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated DP681-001-019, Deck Plate I-rib splice. The welder is identified as #044551 and was observed welding in the 3G (vertical) position using approved Welding Procedure Specification WPS-B-T-3213-B-U3b.

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated SP115-001-053, Side Plate WT stiffener web splice. The welder is identified as #057333 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-B-P-2214-B-U2-FCM-1.

Segment 11DE/11EE

This QA Inspector observed Submerged Arc Welding (SAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated OBE11A-008, Deck Plate transverse splice. The welder is identified as #050295 and was observed welding in the 1G (flat) position using approved Welding Procedure Specification WPS-B-T-223(2)1T-1.

Segment 11DW

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a fillet weld joint. The Weld joint is designated SEG071C-044, 045, Longitudinal Diaphragm web to Bottom Plate. The welder is identified as #053488 and was observed welding in the 2F (horizontal) position using approved Welding Procedure Specification WPS-B-T-2132T.

Segment 11CW

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a fillet weld joint. The Weld joint is designated SEG069C-007, 008, Longitudinal Diaphragm web to Bottom Plate. The welder is identified as #053488 and was observed welding in the 2F (horizontal) position using approved Welding Procedure

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Specification WPS-B-T-2132T.

For the above mentioned welding activities ZPMC Quality Control (QC) Inspectors are identified as Wang Li Yang and Zhou Yuan Yuan. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Segment 11DW/11EW

This QA Inspector observed ABF personnel performing Magnetic Particle Testing on the Deck Plate transverse CJP splice root pass.

Segment 11AE

This QA Inspector observed match drilling bolt holes for the Suspender Bracket to Edge Plate connection at panel point 96.

Cross Beam 17

This QA Inspector observed ZPMC personnel performing Ultrasonic Testing on the Side Panel to Bottom Panel, east and west side.

Segment 11CW/11DW

This QA Inspector observed back gouging of the Side Plate transverse CJP splice root pass, counter weight side.

Lift 10 West

This QA Inspector observed lift 10 West was loaded on the transport ship.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150-0042-2372 , who represents the Office of Structural Materials for your project.

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| Inspected By: | Hernandez,Dan | Quality Assurance Inspector |
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| Reviewed By: | Dsouza,Christopher | QA Reviewer |
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